

54272 DeRev.

Work Order ID 53924

November 23, 2009 2:50:54 PM



Page 1

Item ID: D2841-042

Accept



Setup Start



Revision ID: B

Stop



Item Name: Step Assembly RH, 206 Float

Start Date: 23/11/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 02/12/2009 Req'd Qty: 2.00



Customer:

Reference:

Run Start

Approvals: Process Plan: PL Date: 09-11-23 Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2841

Rev B

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2841-2 using D2622 extrusion as per Dwg D2842 □ 2-Drill extrusion per drawing D2842 using Jig DT 8265 □ 3-Deburr and bevel ends for welding

09-11-24

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

27 502/11/25

(12)

120

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Weld end cap (AFT END ONLY) □ 2-weld lugs as per Dwg D2841 □ using Jig DT 8267 followed by DT 8268 □ A/R AL ROD Batch: 7/11/311 □ 3-Grind end cap welds flush

11/11/44

09-11-25

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53924

November 23, 2009 2:50:54 PM



Page 2

Item ID: D2841-042

Accept



Setup Start



Revision ID: B

Item Name: Step Assembly RH, 206 Float

Stop



Start Date: 23/11/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 02/12/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	QC10- Inspect visual per QSI004- ground welds	0.00							
QC Quality Control	Memo	0.00							
140 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00							
150 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish Hand Finishing	Memo	0.00							

RD 09.11.26

RA
YB

φ

278 09.11.26

09.11.26

2

φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53924

November 23, 2009 2:50:54 PM



Page 4

Item ID:	D2841-042	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	Step Assembly RH, 206 Float					
Start Date:	23/11/2009	Start Qty:	2.00		Cust Item ID:	
Required Date:	02/12/2009	Req'd Qty:	2.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	27809/11/30			LH X2	/		
200 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M112148. Memo START TIME: 10:45 OVEN TEMPERATURE: 320° FINISH TIME: 11:15	0.00 0.00	B209-12-01			2	PH.		
210 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	MD 09/12/02			X2			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53924

November 23, 2009 2:50:54 PM



Page 5

Item ID:	D2841-042	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	Step Assembly RH, 206 Float					
Start Date:	23/11/2009	Start Qty:	2.00	Cust Item ID:		
Required Date:	02/12/2009	Req'd Qty:	2.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220 	HandFinishing	0.00							
HandFinish	Memo	0.00							
Hand Finishing	1-Install inserts as per Dwg D2842 2-Wing Walk as per Dwg D2842 and QSI 005 4.1 Batch: m112623 (wing walk) DiKafler's m 112345 exp: 10/08								
230 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control	INSPECT WORK/WING WALK								
240 	Identify as per dwg & Stock Location:	0.00							
Packaging	Memo	0.00							
Packaging									

WMO 09/11/2002

801.2/02

(2240)

09/12/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53924

November 23, 2009 2:50:54 PM

Page 6

Item ID: D2841-042

Accept

Revision ID: B

Item Name: Step Assembly RH, 206 Float

Start Date: 23/11/2009 Start Qty: 2.00

Required Date: 02/12/2009 Req'd Qty: 2.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

250

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Setup Start

Stop

Run Start

Stop

09/12/07
umf 09-12-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 23, 2009 2:51:02 PM

Page 1

Work Order ID: 53924

Parent Item: D2841-042RevB

Parent Item Name: Step Assembly RH, 206 Float


Comments:

Start Date: 23/11/2009

Required Date: 02/12/2009

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C10L  washer		Purchased	No			100	Each	2,604.000	8.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	100	
103585	100	
Main Warehouse		
ST	2504	
112116	548	
112612	956	
<u>112933</u>	1000	

D2622-120CRevC1

Manufactured No



Step Extrusion

120 Each 95.3200 2.0000

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
WA	95.32	
48612	11.62	
52026	83.7	

X8 MD 09/12/02
11.11.24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 23, 2009 2:51:02 PM

Page 2

Work Order ID: 53924

Parent Item: D2841-042RevB

Parent Item Name: Step Assembly RH, 206 Float

Start Date: 23/11/2009

Required Date: 02/12/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2734RevC

Manufactured

No

120

Each

39.0000

4.0000



Step End Plate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

39

43535

2

48110

37

D3464-1RevA

Manufactured

No

120

Each

32.0000

2.0000



Float Step Mounting Plate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

32

37348

8

44607

24

D3464-3RevA

Manufactured

No

120

Each

27.0000

2.0000



Float Step Mounting Plate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

27

37349

12

37791

15

12.09.11.25

2

12.09.11.25

2

12.09.11.25

2

November 23, 2009 2:51:02 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 23, 2009 2:51:02 PM

Page 3

Work Order ID: 53924

Parent Item: D2841-042RevB

Parent Item Name: Step Assembly RH, 206 Float




Start Date: 23/11/2009

Required Date: 02/12/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3464-5RevA  Float Step Mounting Plate		Manufactured	No			120	Each	6.0000	2.0000		<u>09.11.25</u>	
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>25427</div> <div>Loc Qty</div> <div>6</div> <div>6</div> <div>Loc Code</div>												
D3464-7RevA  Float Step Mounting Plate		Manufactured	No			220	Each	25.0000	2.0000		<u>09.11.25</u>	
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>25428</div> <div>44608</div> <div>Loc Qty</div> <div>25</div> <div>6</div> <div>19</div> <div>Loc Code</div>												
MS27039C1-07  screw		Purchased	No			220	Each	46.0000	8.0000			
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>107008</div> <div>111424</div> <div>Loc Qty</div> <div>46</div> <div>1</div> <div>45</div> <div>Loc Code</div>												

November 23, 2009 2:51:02 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 4

November 23, 2009 2:51:02 PM

Work Order ID: 53924



Parent Item: D2841-042RevB



Parent Item Name: Step Assembly RH, 206 Float

Start Date: 23/11/2009

Required Date: 02/12/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1329C3KB130		Purchased	No			220	Each	98.0000	8.0000			
insert												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

98

111981

98

NAS1515H3L

Purchased

No

220

Each

266.0000

8.0000



WASHER



Warehouse Loc Qty Loc Code

Location

OFFSHORE

FG

40

102472

40

Main Warehouse

ST

226

110450

2

111819

224

X8 MO 09/12/02

X8 MO 09/12/02

November 23, 2009 2:51:02 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

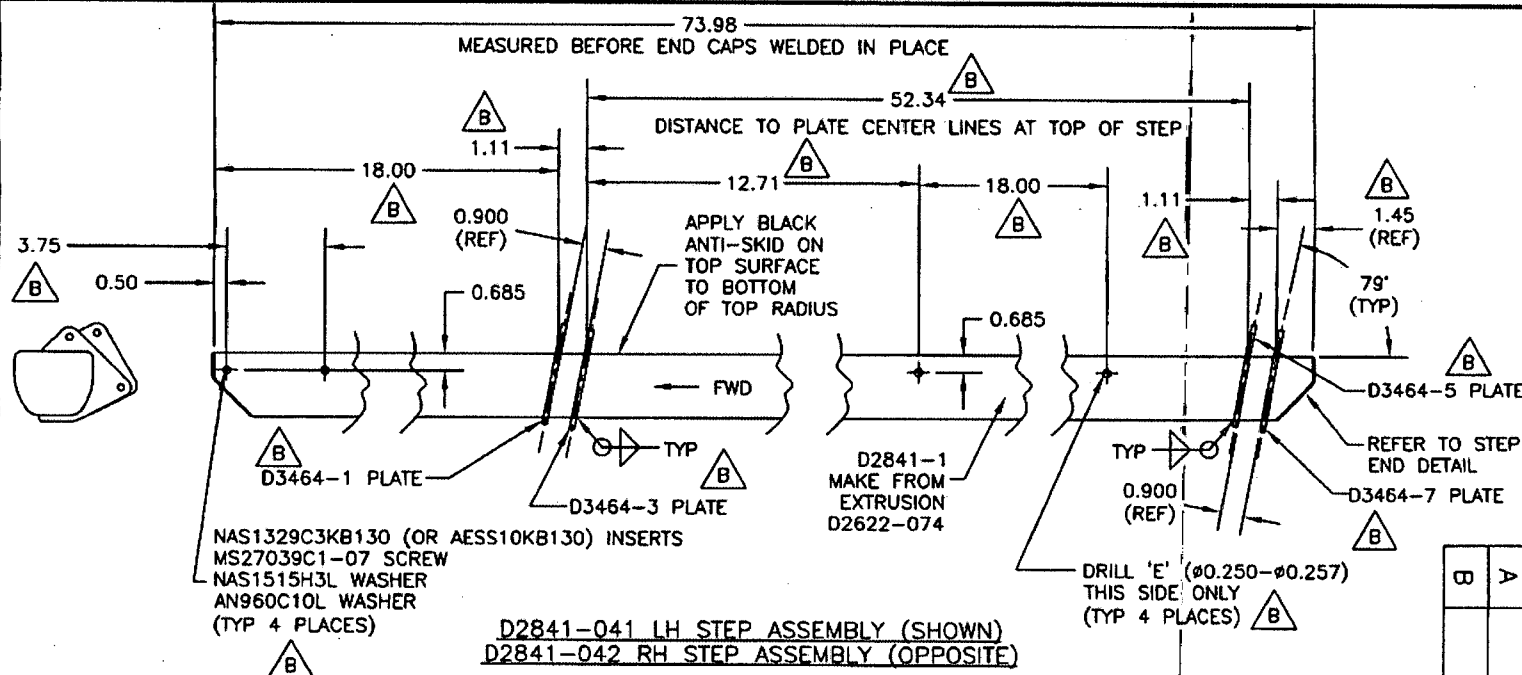
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	KE	DRAWN BY	DATE	CHECKED	APPROVED	DRAWING NO.	REV. B
			05.09.21			D2841	SHEET 1 OF 1
			05.09.21			206B FLOAT STEP ASSEMBLY	SCALE NTS
			05.09.21			RE-DESIGN, ADD D2843-1/-3/5/7	

DART AEROSPACE USA, INC.
PORT HADLOCK, WA



D2841-041 LH STEP ASSEMBLY (SHOWN)
D2841-042 RH STEP ASSEMBLY (OPPOSITE)

D2841-041/-042 STEP ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
X	X	D2841-041	LH STEP ASSEMBLY
X	X	D2841-042	RH STEP ASSEMBLY
1	1	D2622-074	EXTRUSION
1	1	D3464-1	PLATE
1	1	D3464-3	PLATE
1	1	D3464-5	PLATE
1	1	D3464-7	PLATE
2	2	D2734	END PLATE
4	4	NAS1329C3KB130 (OR AESS10KB130)	INSERT
4	4	MS27039C1-07	SCREW
4	4	NAS1515H3L	WASHER
4	4	AN960C10L	WASHER

NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004

D2841-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED

05.11.14

RETURN TO
ENGINEER
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK OFFICE
NO. 539247
H/02 11-23